

5/13

DART AEROSPACE LTD	Work Order:	22906
Description: Wheel Assembly	Part Number:	D3233-041
Dwg: D3233 Rev. B	Qty:	4
Ref:	Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																												
1	DC	Issue Traveler	<i>[Signature]</i>	05.03.31	4																												
2	MFA	Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D3233-7</td> <td>Shaft Sleeve</td> <td>B22860</td> </tr> <tr> <td>2</td> <td>D3233-9</td> <td>Tire & Rim Assembly</td> <td>B22421A</td> </tr> <tr> <td>2</td> <td>D3332-5</td> <td>Hub Sleeve</td> <td>B22860 B22679</td> </tr> <tr> <td>4</td> <td>NKI 30/20</td> <td>Bearing & Inner Sleeve</td> <td>M16867</td> </tr> <tr> <td>8</td> <td>Shim Stock</td> <td>0.004" thick Brass Shim Stock</td> <td>M17235</td> </tr> <tr> <td>4</td> <td>35x45x7</td> <td>Axel Seal</td> <td>M17019</td> </tr> </tbody> </table> or CR 35x45x7 HMS4 R	Qty	Part Number	Description	Batch	2	D3233-7	Shaft Sleeve	B22860	2	D3233-9	Tire & Rim Assembly	B22421A	2	D3332-5	Hub Sleeve	B22860 B22679	4	NKI 30/20	Bearing & Inner Sleeve	M16867	8	Shim Stock	0.004" thick Brass Shim Stock	M17235	4	35x45x7	Axel Seal	M17019	<i>[Signature]</i>	05/04/07	4
Qty	Part Number	Description	Batch																														
2	D3233-7	Shaft Sleeve	B22860																														
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2	D3332-5	Hub Sleeve	B22860 B22679																														
4	NKI 30/20	Bearing & Inner Sleeve	M16867																														
8	Shim Stock	0.004" thick Brass Shim Stock	M17235																														
4	35x45x7	Axel Seal	M17019																														
3	MFA	Press out bearings that are supplied with D3233-9 wheel and discard them.	<i>[Signature]</i>	05/04/07	4																												
4	MFA	Cut shims and assemble as per Dwg D3233	<i>[Signature]</i>	05/04/07	4																												
5	MFA	Spray inside hub and bearing with LPS-3 & block hole with a clean dry rag for storage.	<i>[Signature]</i>	05/04/07	4																												
6	QC5	Inspect work to Step 5	<i>[Signature]</i>	05/04/07	4																												
7	ST	Identify and Stock	<i>[Signature]</i>	05/04/07	4																												
8	AC	Cost / part: <u>268.16</u>	<i>[Signature]</i>	05.05.20	1																												
9	DC	Close W/O <u>271.26</u> Inspect Level 21	<i>[Signature]</i>	05.05.24	4																												

Rev	Date	Change	Revised By	Approved
A	05.01.12	New issue	KJ/JLM	<i>[Signature]</i>
B	05.03.03	Made in house	KJ/JLM	<i>[Signature]</i>

RELEASED
[Signature] 05.03.15

D3233-041
 B22421A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

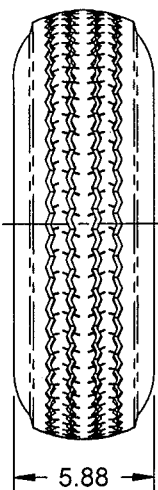
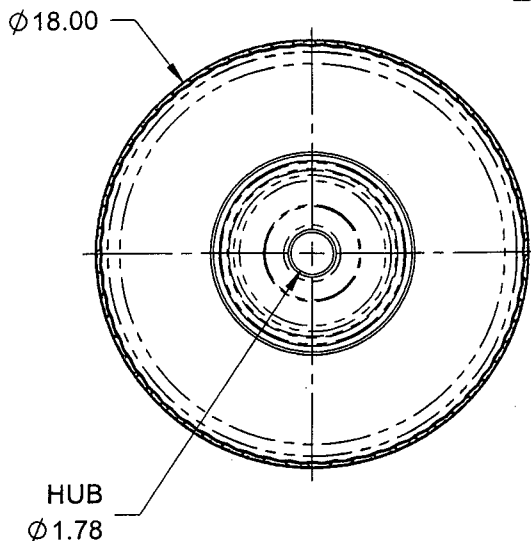
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

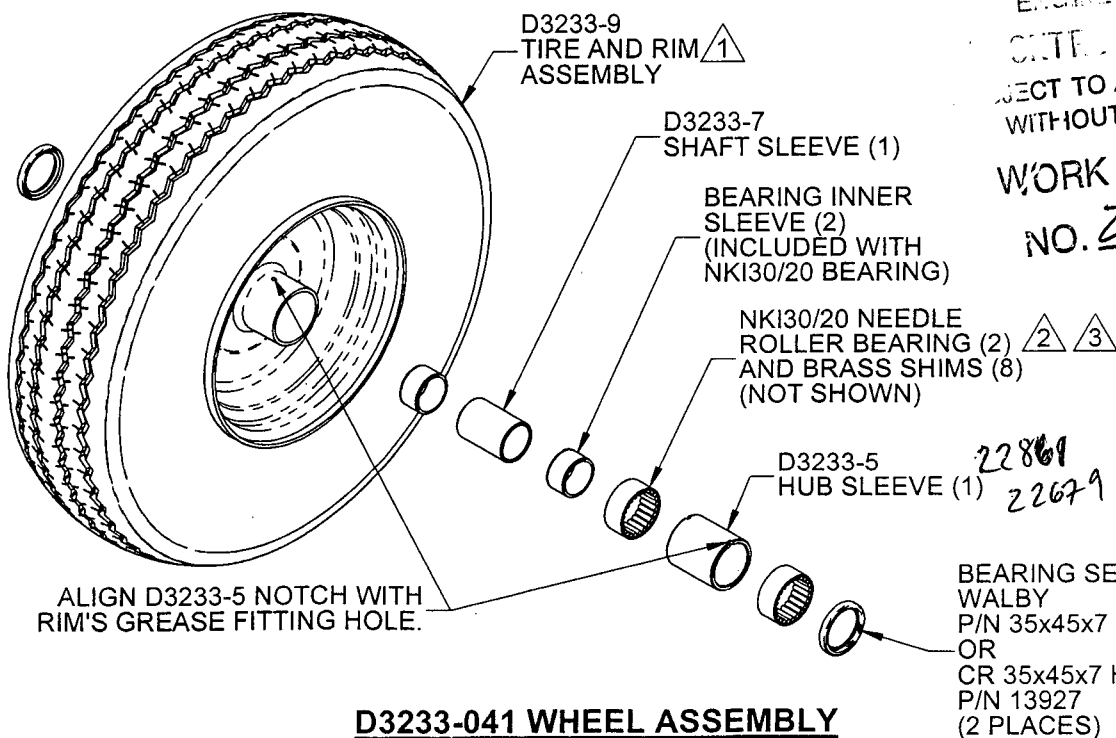
PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3233	REV. B SHEET 1 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	



WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

* MANUFACTURER'S RECOMENDATIONS ARE 75 PSI FOR HIGH SPEED USE.



D3233-041 WHEEL ASSEMBLY

NOTES:

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH
(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

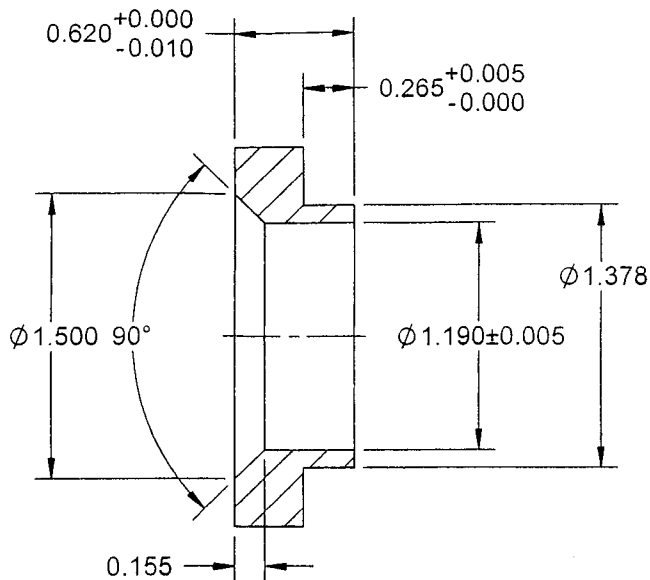
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RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 22906

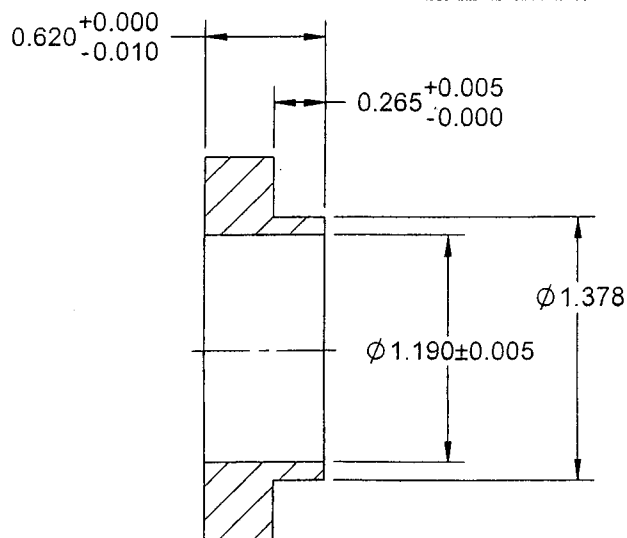
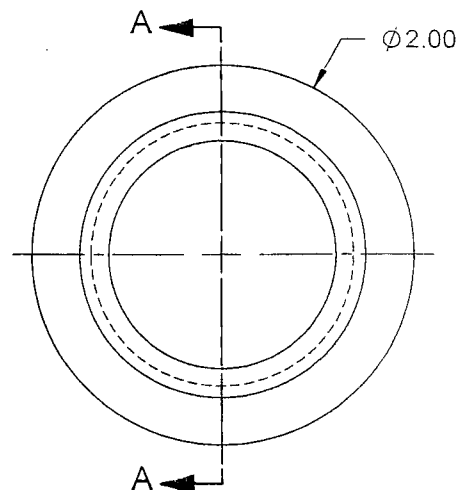
PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3233	REV. B SHEET 2 OF 3
DATE 05.03.08	TITLE WHEEL ASSEMBLY		SCALE 1:1



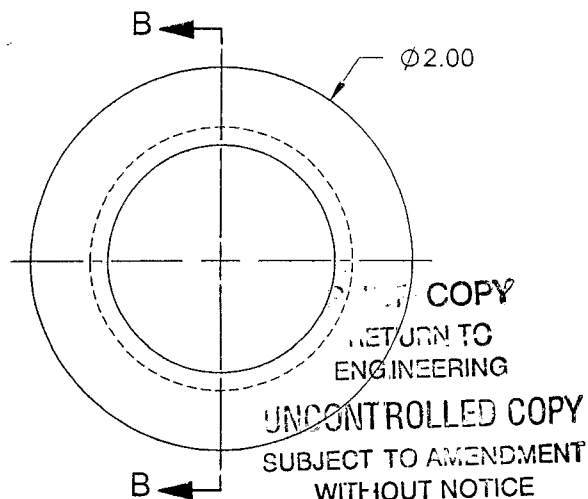
SECTION A-A

D3233-1 INSIDE WASHER



SECTION B-B

D3233-3 OUTSIDE WASHER



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WORK ORDER

22906

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 01, 2005
07:18 am

Work Order No : 0022906
Project Name : D3233-041
Project For : WK513
Work Order Type : Main
Main WO Number :
House Part Number : D3233-041
Description : Wheel Assembly
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 04-01-05
Est Finish Date : 04-04-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

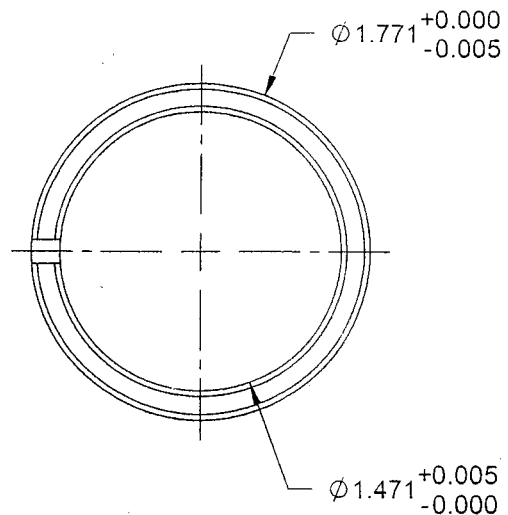
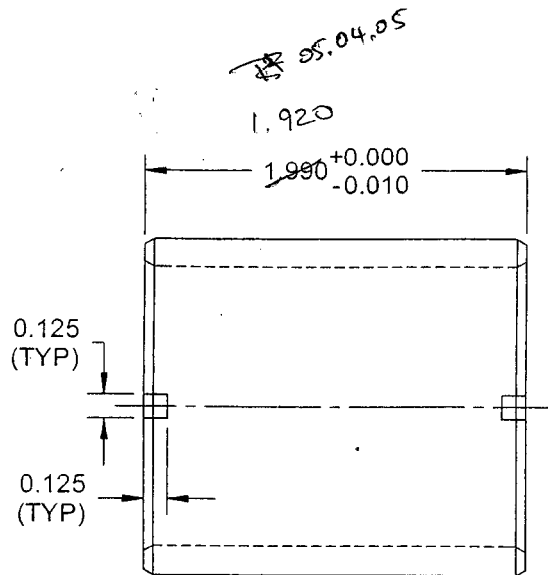
Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

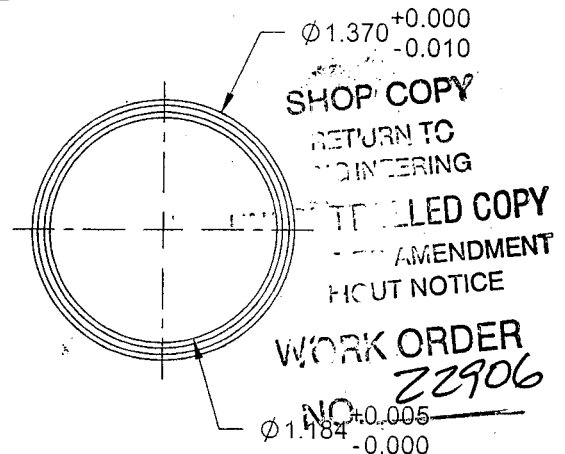
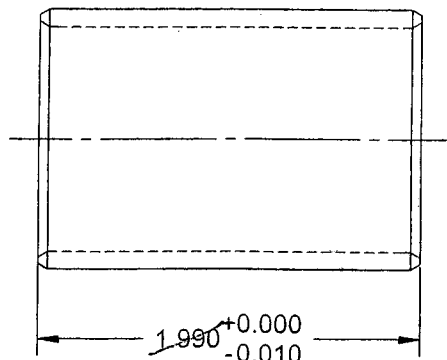
	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE	05.03.08	TITLE WHEEL ASSEMBLY	SCALE 1:1



D3233-5 HUB SLEEVE



D3233-7 SHAFT SLEEVE

NOTES:

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